

Shp Sept 23

Work Order ID 72519

Wednesday, July 27, 2011 3:16:27 PM

Page 1

Item ID: D4055-041

Accept

Revision ID:

Item Name: Fuel Tank Assembly

Start Date: 7/27/2011 Start Qty: 1.00

Required Date: 8/8/2011 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan:

Date: 11-07-27

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4055

B

100

Weld per dwg A/R Aluminum rod Batch: 114514
117884 0.00

Large Fab

Memo

0.00

Large Fab

1- weld D4023-3 cap, D3999-11 earth tab and D4008-11 hinge onto D4055-11 as per dwg D4055

2- Weld D4001-1 and D4000-5 onto D4055-1 Top

2- Weld D4055-9 and D4055-11 together

2- weld D3999-041/-043 doubler followed by D3999-9 inside tank, ensure doubler and angle holes line-up for D4000-047

3- Weld D4000-043 and D4000-045 on tank as per dwg.

4- Instal D4000-9 grommets as per dwg, Weld D4055-3 aft end as per dwg, locate D4000-1 fitting using locating jig DTXXXX and weld as per dwg

5- Weld D4055-7 fwd end

11.09.08 1 φ

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Setup Start



Revision ID:

Item Name: Fuel Tank Assembly

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Start Date: 7/27/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 8/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 2E11/09/08

121

Weld per dwg A/R Aluminum rod Batch: 114514

0.00



Large Fab

Memo

0.00

Large Fab

1-Weld top D4055-1

11.09.13

1 0

P10 →

122

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/09/13

W/O: 72519		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4055-041 PAR #: N/A Fault Category: Long FAB/welding NCR: Yes No DQA: AS Date: 11.09.29
 Resolution: Re work Scrap Disposition: Re work + SCRAP QA: N/C Closed Date: 11/09/29






NCR:		WORK ORDER NON-CONFORMANCE (NCR) #122.10 + 23.88 = 145.98						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/09/13	#122	AFTER welding weldline tries to remain D4000-045 AND ENDED UP STRIPPING THE THREADS on both. D4000-045	11.09.13 GS1042	→ SCRAP + DESTROY D4000-045 Qty x1 + Reorder B #72078	pk 11.09.13		11.09.13	11/09/13
		D4000-045 + D4000-1 Scraping both R.C. Process. (Parts were machined correctly + welded correctly.)	11.09.13 GS1042	→ cut out + remove D4000-1 AND Reorder B #71896 Qty x1	pk 11.09.13	11/09/14	11.09.13	11/09/13
			11.09.13 GS1042	(Request that AFTER welding "Taps" should be passed in all thread parts.)	pk 11.09.13		11.09.13	11/09/13



NOTE: Date & initial all entries




Work Order ID 72519

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Item ID:	D4055-041	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Fuel Tank Assembly					
Start Date:	7/27/2011	Start Qty:	1.00		Cust Item ID:	
Required Date:	8/8/2011	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
123 	QC5- Inspect part completeness to step on W/O	0.00							
QC Quality Control	Memo ***Pressure Test as per dwg D4055*** - TESTED IAW Dwg As well as - Filled with water - Submerged in water tank	0.00							
130 	Chemical Conversion Coat per QSI005 4.1	0.00							
HandFinish Hand Finishing	Memo 1- brush alodine on tank. No alodine inside	0.00							
140 	QC3- Inspect Part Finish	0.00							
QC Quality Control	Memo	0.00							

11/09/14
/ S workup

IX Ø M-11/09/14

~~11/09/22~~
BR 11-09-22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Reference:

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Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

170



Powdercoat

Powder Coating

Grey Sandtex (Ref 4.3.5.6) per QST005 4.3

0.00

Memo

0.00

Mask prior to powdercoat

Start Time:

Oven Temperature:

Finish Time:

8:10
320 OF
8:40

IX Ø M/L 11/09/15

180



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

1 Ø M/L 11/09/15

185



SprayPaint

Spray Painting

Memo

0.00

Seal inside of tank using Sloshing

PR-1005-L

Sealer as per dwg

M116444

1 Ø M/L 11/09/20

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Cust Item ID:

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

190



Small Fab

Memo

0.00

0.00

Small Fab

Assemble as per dwg

EBH 10/9/22

200



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

220



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

8 more

(H)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

230



Packaging

Identify as per dwg & Stock Location: _____

0.00

PP

73261

11/9/23

Memo

0.00

Packaging

240



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

11/9/27
ME
11-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng/ Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Page 1

Work Order ID: 72519

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly





Start Date: 7/27/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev A 10.03.08 new issue prelim EC verified by:DD IPP Rev:B
10.05.17 ECN10-562 DD verf:EC IPP Rev C: 10.11.23
revised pick list EC verified by:DD IPP Rev D: 11.06.01 per D4055
revB EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3997-1  Placard		Manufactured	No			190	Each	6.0000	1	1			
<div> <div>Location</div> <div>ST104</div> <div>68930</div> <div>71177</div> </div> <div> <div>Loc Qty</div> <div>6</div> <div>2</div> <div>4</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> <div></div> </div>													
D3997-5  Placard		Manufactured	No			190	Each	8.0000	2	2			
<div> <div>Location</div> <div>ST104</div> <div>71170</div> </div> <div> <div>Loc Qty</div> <div>8</div> <div>8</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3997-11  Placard		Manufactured	No			190	Each	5.0000	1	1			
<div> <div>Location</div> <div>ST104</div> <div>65124</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													
D3997-17  Placard		Manufactured	No			190	Each	5.0000	1	1			
<div> <div>Location</div> <div>ST104</div> <div>65125</div> </div> <div> <div>Loc Qty</div> <div>5</div> <div>5</div> </div> <div> <div>Loc Code</div> <div></div> <div></div> </div>													

B73509

B72611

B726148

B72617 11/9/22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Work Order ID: 72519

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/27/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D3997-29

Manufactured No

190 Each

5.0000

1



Placard

Location

Loc Qty

Loc Code

ST104

5

65126

5

D3997-43

Manufactured No

190 Each

4.0000

1



Placard

Location

Loc Qty

Loc Code

ST104

4

65127

4

D3999-7

Manufactured No

100 Each

1.0000

1



Corner

Location

Loc Qty

Loc Code

ENG

1

55645

1

D3999-9

Manufactured No

100 Each

0.0000

1



Angle

D3999-11

Manufactured No

100 Each

0.0000

1



Earth Tab

D3999-041

Manufactured No

100 Each

2.0000

1



Baffle Assembly, Aft

Location

Loc Qty

Loc Code

WA014

2

70248

2

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Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 72519

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/27/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D3999-043 Manufactured No
Baffle Assembly, Fwd

100 Each

2.0000

1

1

Location

WA014

371693

Loc Qty

2

Loc Code

70249

2

100 Each

6.0000

1

1

✓ D4000-1 Manufactured No
Fuel Supply Fitting

Location

WA

Loc Qty

4

Loc Code

71896

4

WA013

2

65716

2

100 Each

6.0000

1

1

✓ D4000-5 Manufactured No
Fuel Tank Vent Fitting

Location

WA013

Loc Qty

6

Loc Code

72427

6

100 Each

10.0000

3

3

✓ D4000-9 Manufactured No
Grommet

Location

WA013

Loc Qty

10

Loc Code

70250

10

100 Each

0.0000

1

1

D4000-043 Manufactured No
Drain Fitting Assembly, Fwd

372085 = 1



11.09.08 372085 = 1

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W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID: 72519

Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/27/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4000-045

Manufactured No

100

Each

3.0000

1

1



Fuel Pickup Fitting Assembly



11.09.13

Location

Loc Qty

Loc Code

WA

372078=1

3

71669

SCRAP

3

100

Each

0.0000

1

1

✓ D4000-041

Manufactured No



Drain Fitting Assembly, Aft

372084=1



11.09.08 B72084

✓ D4001-1

Manufactured No

100

Each

1.0000

1

1



Fitting



11.09.08

Location

Loc Qty

Loc Code

WA013

B71693

1

66840

1

✓ D4008-11

Manufactured No

100

Each

7.0000

1

1



Hinge Half



11.09.08

Location

Loc Qty

Loc Code

ST108

7

65445

3

67650

4

D4008-041

Manufactured No

190

Each

5.0000

1

1



Fuel Filler Splash Guard Assembly



~~B59400~~ 11/9/22
B72200

Location

Loc Qty

Loc Code

ST108

5

70140

5

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W/O:		WORK ORDER CHANGES					
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Parent Item Name: Fuel Tank Assembly

Start Date: 7/27/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4023-3

Manufactured No

100

Each

8.0000

1

1



Cap and Flange



11.09.07

Location

Loc Qty

Loc Code

ST110

4

72243

4

WA

4

70204

4

D4025-1

Manufactured No

100

Each

3.0000

1



Fuel Quantity Sender



Location

Loc Qty

Loc Code

ST142

3

69502

3

D4055-11

Manufactured No

100

Each

8.0000

1

1



Tank Front and Bottom



11.09.07

Location

Loc Qty

Loc Code

WA

3

70201

3

WA013

5

65447

2

68500

3

D4055-9

Manufactured No

100

Each

3.0000

1

1



Tank Back



11.09.08

Location

Loc Qty

Loc Code

WA013

3

63948

1

65451

1

66842

1

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Parent Item Name: Fuel Tank Assembly

Start Date: 7/27/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

✓ D4055-7

Tank Fwd End

Manufactured No

100

Each

2.0000

1

1



11.09.13

Location


Loc Qty

Loc Code

WA014 B71700
65450
70251

2
1
1

1

✓ D4055-5

Tank Upper Cut Out

Manufactured No

100

Each

3.0000

1

1



11.09.08

Location


Loc Qty

Loc Code

WA013
67737

3
3

1

✓ D4055-3

Tank Aft End

Manufactured No

100

Each

2.0000

1

1



11.09.01

Location


Loc Qty

Loc Code

WA B71699
68501
WA014
70447

1
1
1
1

1

✓ D4055-1

Tank Top

Manufactured No

100

Each

1.0000

1

1



11.08.31

Location

Loc Qty

Loc Code

WA013 B71701
65446

1
1

1

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Parent Item: D4055-041

Parent Item Name: Fuel Tank Assembly

Start Date: 7/27/2011

Required Date: 8/8/2011

Start Qty: 1.00

Required Qty: 1.00

D4057-1 Manufactured No

100 Each

44.0000

3

3



Retaining Ring

Location

Loc Qty

Loc Code

WA013

44

55826

8

71166

36

AN3H5A

Purchased No

190 Each

57.0000

5

5



Bolt

Location

Loc Qty

Loc Code

ST350

7

116704

7

ST351

50

118112

50

NAS1149D0363J

Purchased No

190 Each

2,736.000

5

5



Washer

Location

Loc Qty

Loc Code

ST298

2736

117505

366

117601

370

118077

2000

D4404-1

Manufactured No

190 Each

6.0000

1



Cushion

Location

Loc Qty

Loc Code

ST404

6

70247

6

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Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

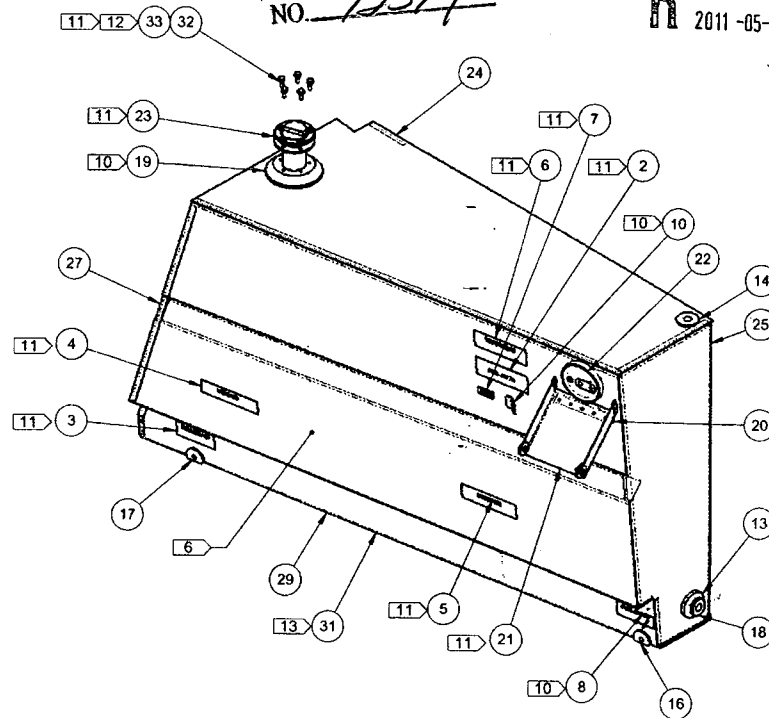
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WORK ORDER
NO. 72519

11-07-27

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2011-05-30
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ITEM NO.	QTY. .041	PART NUMBER	DESCRIPTION
1	X	D4055-041	FUEL TANK ASSEMBLY
2	1	D3997-1	PLACARD "FUEL JET A1"
3	2	D3997-5	PLACARD "AUX FUEL DRAIN"
4	1	D3997-11	PLACARD "LOADING"
5	1	D3997-17	PLACARD "STOWAGE"
6	1	D3997-29	PLACARD "WARNING"
7	1	D3997-43	PLACARD "EARTH"
8	1	D3999-7	CORNER
9	1	D3999-9	ANGLE
10	1	D3999-11	EARTH TAB
11	1	D3999-041	BAFFLE ASSEMBLY, AFT
12	1	D3999-043	BAFFLE ASSEMBLY, FWD
13	1	D4000-1	FUEL SUPPLY FITTING
14	1	D4000-5	FUEL TANK VENT FITTING
15	3	D4000-9	GROMMET
16	1	D4000-041	AFT FUEL SUMP DRAIN ASSEMBLY
17	1	D4000-043	FORWARD FUEL SUMP DRAIN ASSEMBLY
18	1	D4000-045	FUEL PICK UP AND STRAINER ASSEMBLY
19	1	D4001-1	FITTING
20	1	D4008-11	TANK HINGE HALF
21	1	D4008-041	FUEL FILLER SPLASH GUARD ASSEMBLY
22	1	D4023-3	FUEL CAP
23	1	D4025-1	FUEL SENDER
24	1	D4055-1	TANK TOP
25	1	D4055-3	TANK AFT END
26	1	D4055-5	TANK UPPER CUT OUT
27	1	D4055-7	TANK FORWARD END
28	1	D4055-9	TANK BACK
29	1	D4055-11	TANK FRONT AND BOTTOM
30	3	D4057-1	RETAINING RING
31	1	D4404-1	CUSHION
32	5	AN3H5A	BOLT
33	5	NAS1149D0363J	WASHER

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: TOUCH UP CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "GREY SANDEX" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D350-794-041" USING D2729-1 RED DECAL
- 7) WEIGHT: 27.57 lbs
- 8) WELD PER DART QSI 004
- 9) CAP ALL TANK ACCESS POINTS AND PRESSURIZE TANK TO 1.5 PSI AFTER ASSEMBLY. VERIFY NO LEAKS
- 10) MASK PRIOR TO POWDER COAT
- 11) INSTALL AFTER POWDER COAT. REMOVE TEXTURED FINISH LOCALLY PRIOR TO INSTALLATION
- 12) LOCKWIRE BOLTS AFTER INSTALLATION PER AC 43.13 OR MS33540
- 13) INSTALL CUSHION AFTER POWDER COAT USING CONTACT CEMENT. TRIM TO FIT IF REQUIRED.

D4055-041 FUEL TANK ASSEMBLY

B	MOVE CAP POSITION AND CHANGE CAP DESIGN, CHANGE FINISH REQUIREMENTS FOR ALL PARTS, ADD CUSHION UNDER TANK, CORRECT PART NUMBERS	11.05.12
A	NEW ISSUE	10.04.16
REV.	DESCRIPTION	DATE
DESIGN		
DRAWN		
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	11.05.12	

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4055	REV. B
TITLE TANK	SHEET 1 OF 15
SCALE NTS	
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

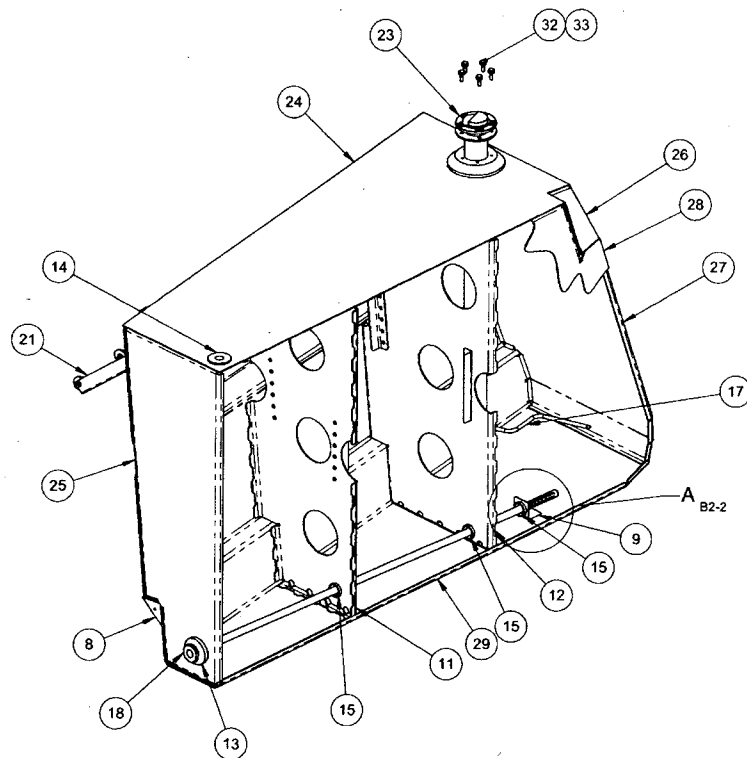
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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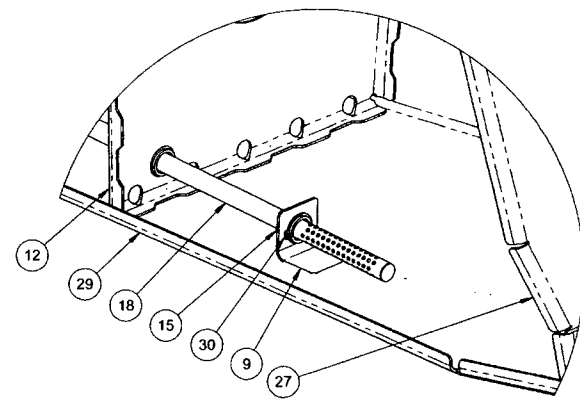
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D4055-041 FUEL TANK ASSEMBLY
D4055-9 TANK BACK REMOVED
TO SHOW INTERIOR DETAIL



DETAIL A
ROTATED FOR CLARITY
SCALE 2X
B6-2

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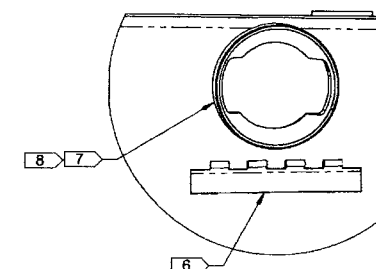
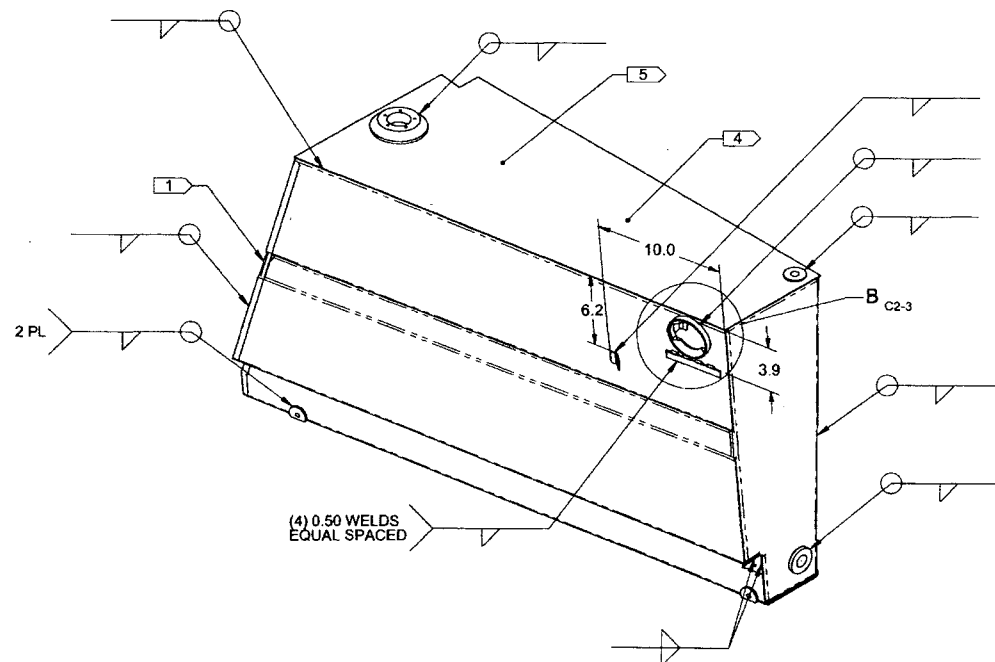
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DETAIL B
ROTATED FOR CLARITY
SCALE 2X

C4-3

D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL

NOTES:

- 1) TRIM FLANGES AS REQUIRED TO FIT ASSEMBLY
- 2) FINAL CHECK BEFORE LAST PANEL INSTALLED
 - END OF FUEL PICK UP TUBE IS 0.60 OFF THE TANK FLOOR AND 1.96 FROM SIDE WALL
 - FWD AND AFT DRAIN TUBES EXTEND TO CENTER OF TANK
 - ALL SWarf REMOVED
- 3) AFTER FINAL ASSEMBLY, SLOSH TANK WITH MIL-S-4383 OR EQUIVALENT (PR-1005-L BUNA-N-SLOSH)
- 4) ACCEPTABLE TO DRILL 6 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO AFT BAFFLE (1 HOLE PER BAFFLE TAB)
- 5) ACCEPTABLE TO DRILL 7 (TYP) $\varnothing 0.312$ HOLES IN TANK TOP TO WELD TOP TO FWD BAFFLE (1 HOLE PER BAFFLE TAB)
- 6) CENTER HINGE BELOW FUEL CAP FLANGE
- 7) POSITION FUEL CAP FLANGE AS SHOWN, ELONGATED HOLE APPROXIMATELY HORIZONTAL
- 8) POSITION FUEL CAP FLANGE SO THAT INNER FACE IS FLUSH WITH INSIDE OF TANK

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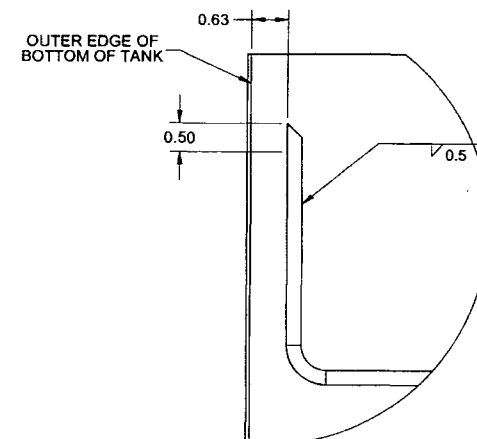
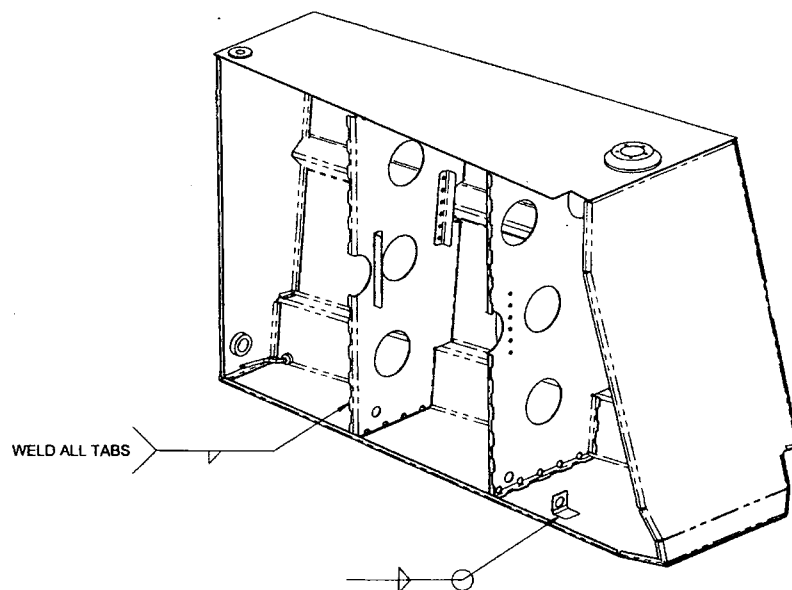
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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**DRAIN TUBE INSTALLATION - TYP
VIEWED FROM ABOVE
FWD END SHOWN, AFT END OPPOSITE**

**D4055-041 FUEL TANK ASSEMBLY
WELDING DETAIL**

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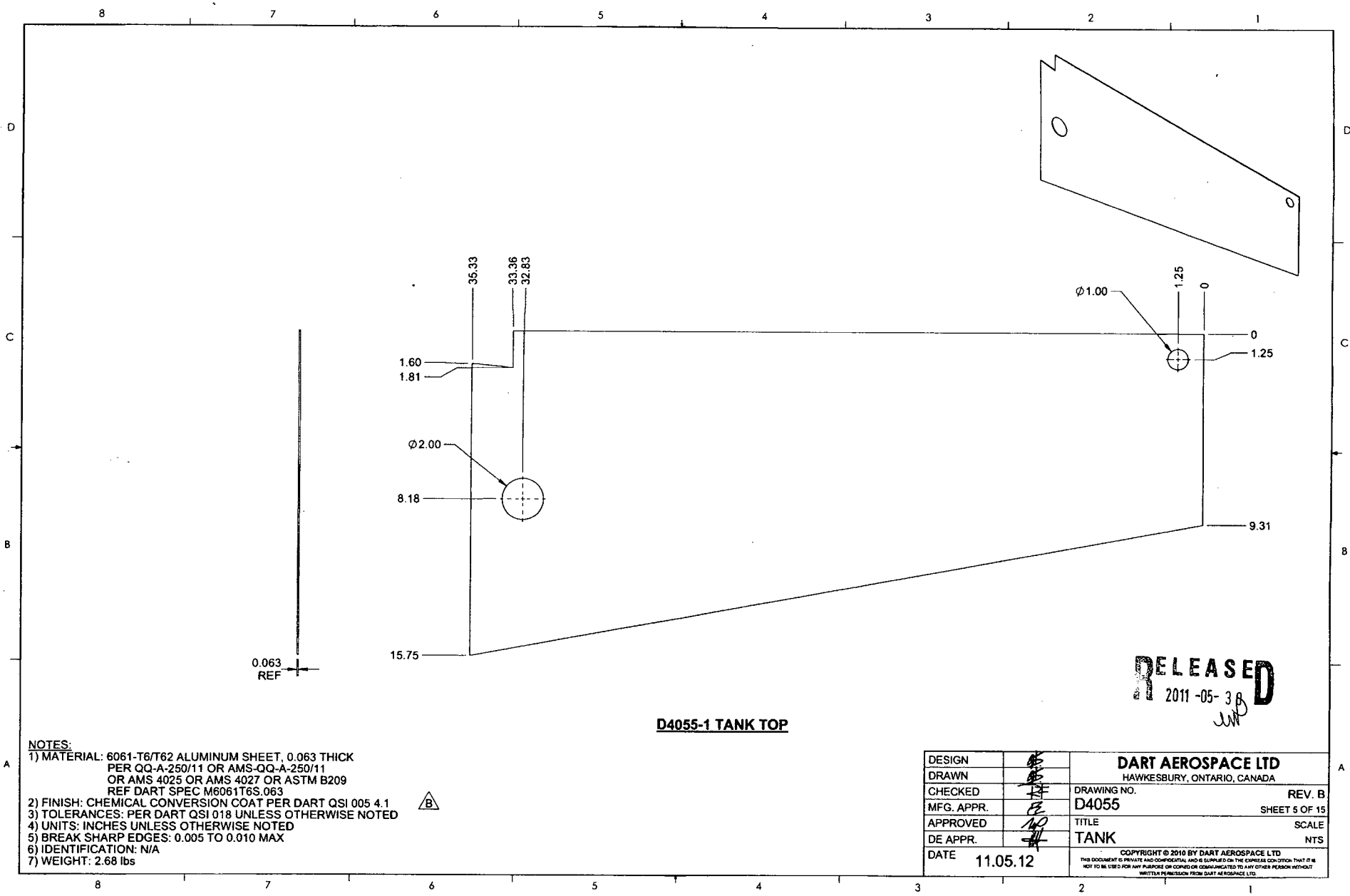
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D4055-1 TANK TOP

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.68 lbs



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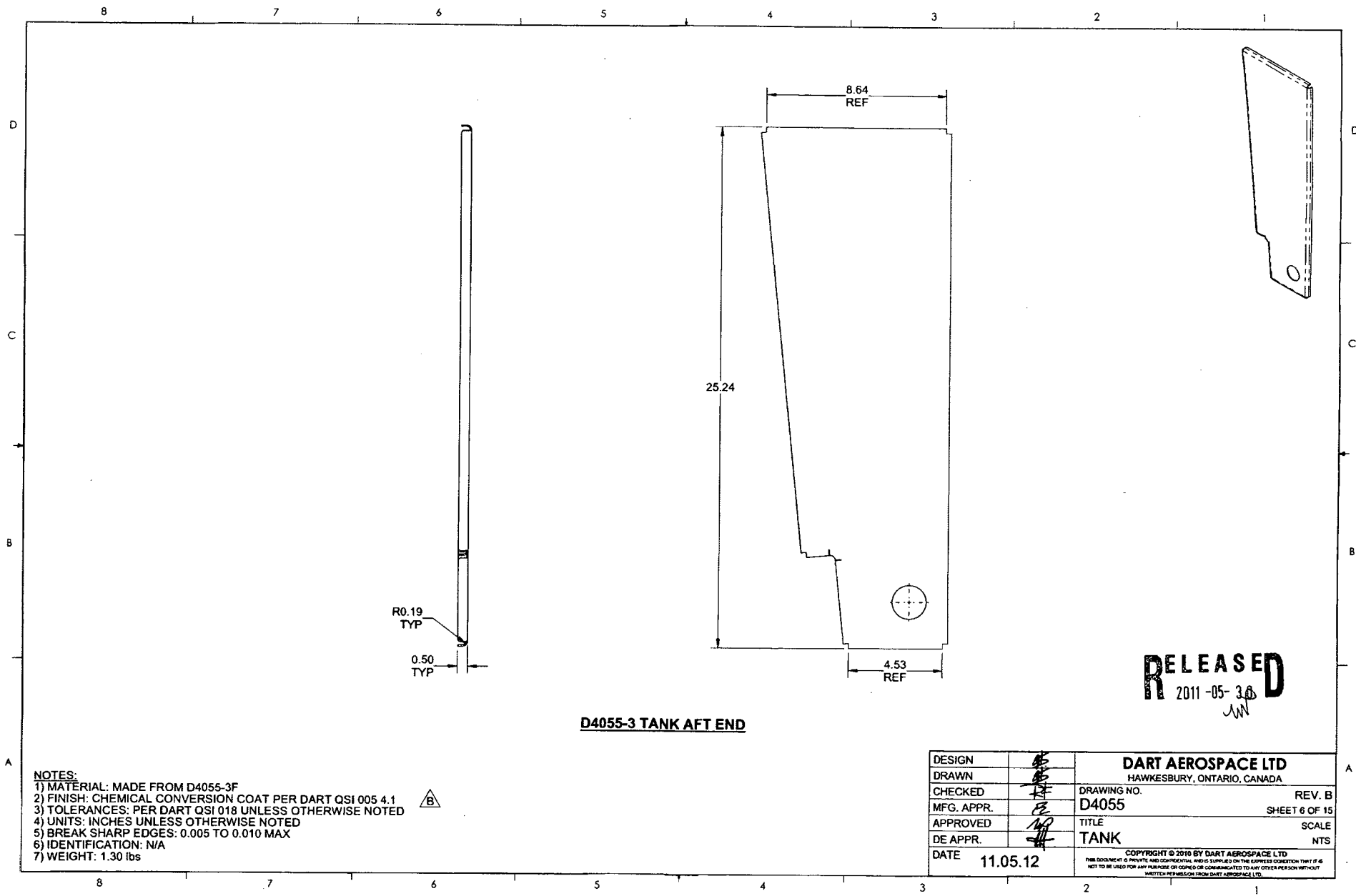
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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D4055-3 TANK AFT END

RELEASED
2011-05-30
JNN

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-3F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs



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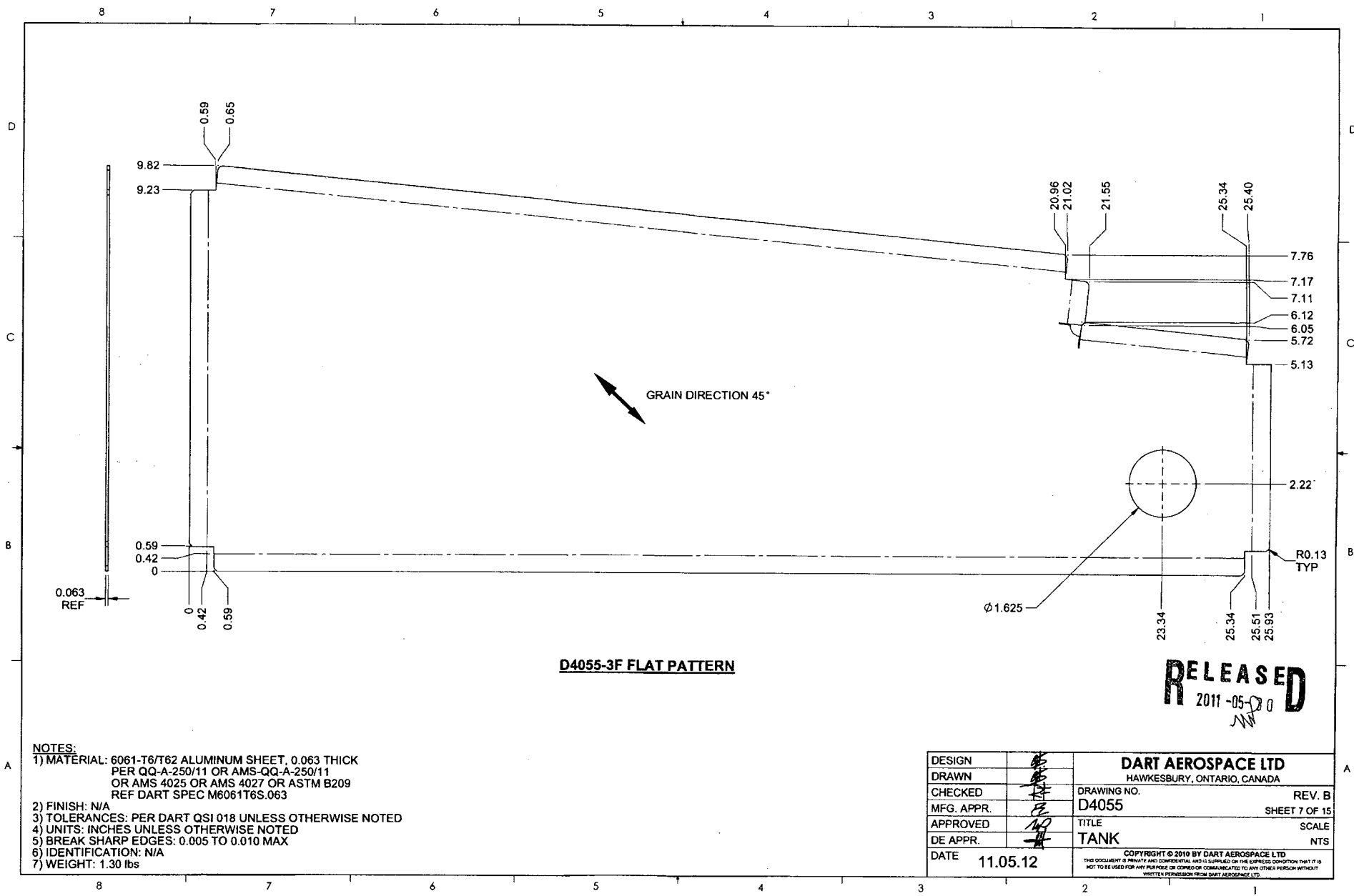
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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D4055-3F FLAT PATTERN

RELEASED
2011-05-20

- NOTES:
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 1.30 lbs

DESIGN	JS	DART AEROSPACE LTD	
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DATE	STEP	PROCEDURE CHANGE				By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

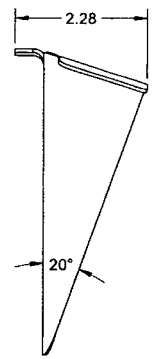
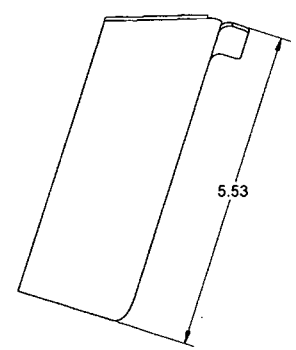
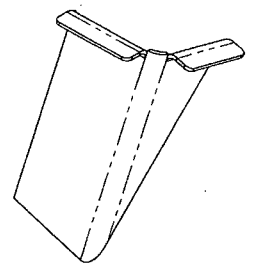
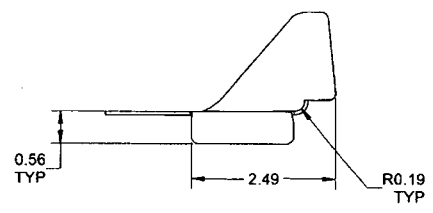
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D4055-5 UPPER CUT OUT

RELEASED
2011-05-30
NN

NOTES:

- 1) MATERIAL: MADE FROM D4055-5F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs



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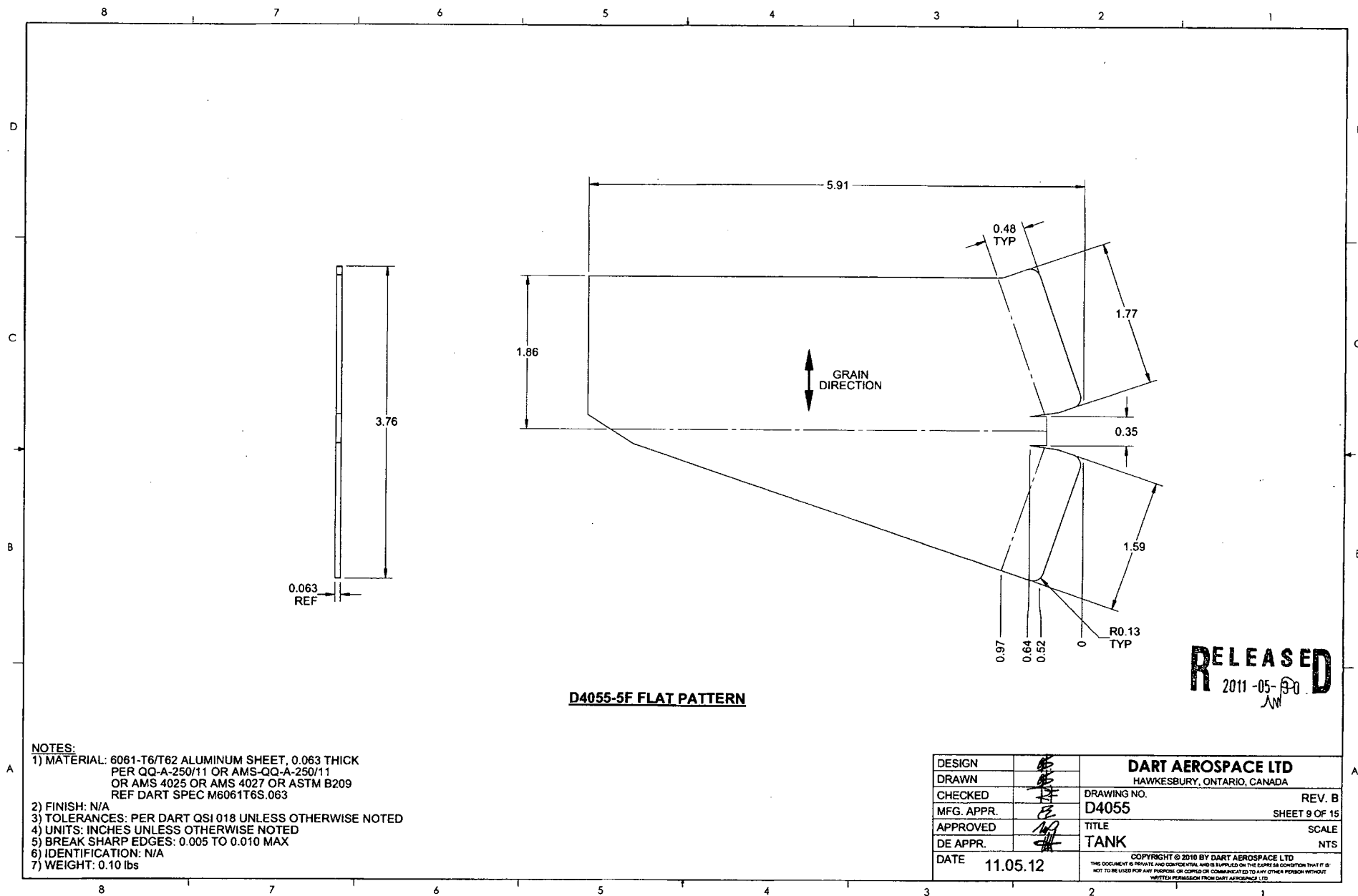
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2011-05-30

- NOTES:**
- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.10 lbs

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MFG. APPR.		D4055	SHEET 9 OF 15
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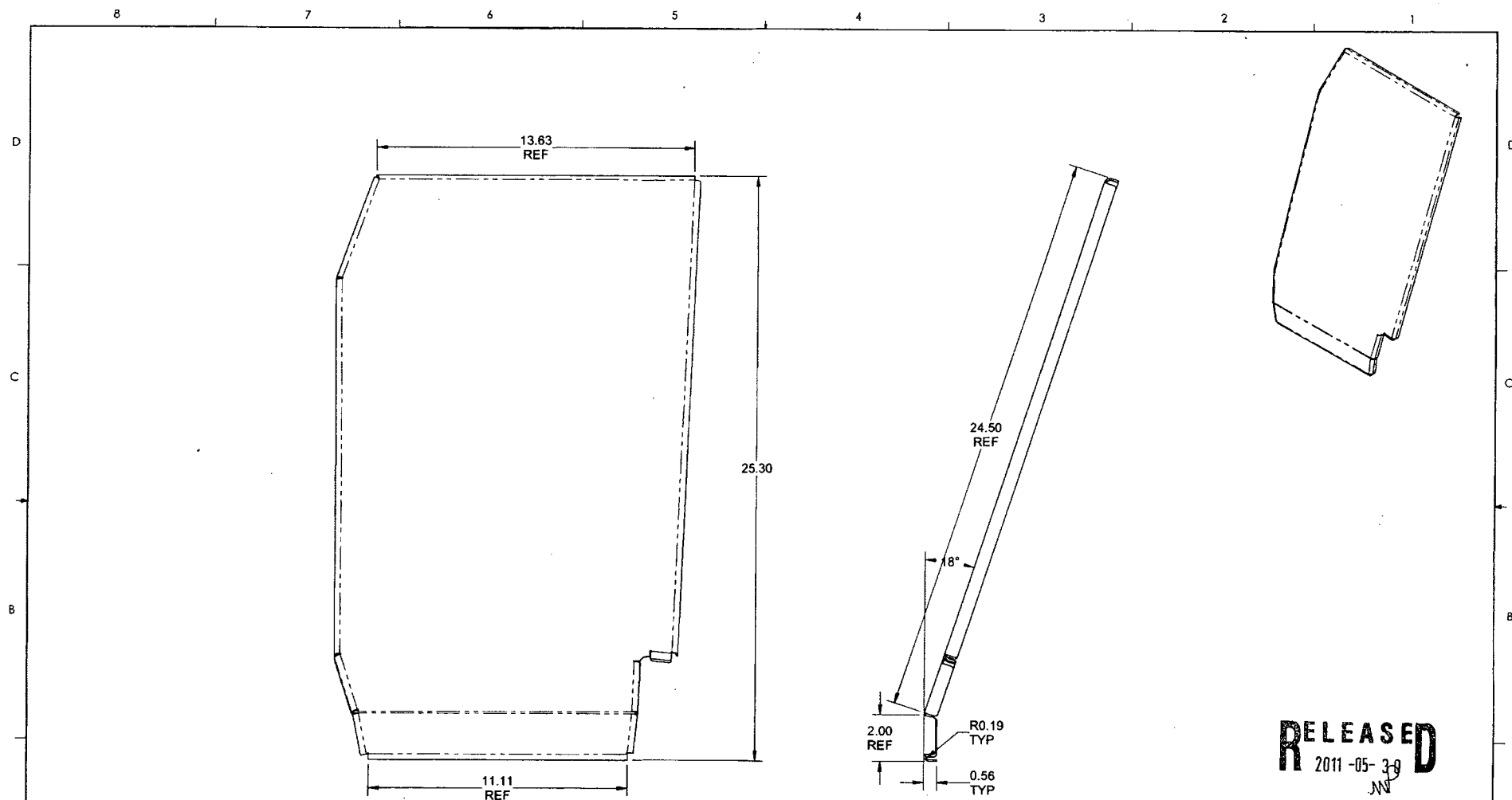
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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D4055-7 TANK FORWARD END

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-7F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 2.56 lbs



DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
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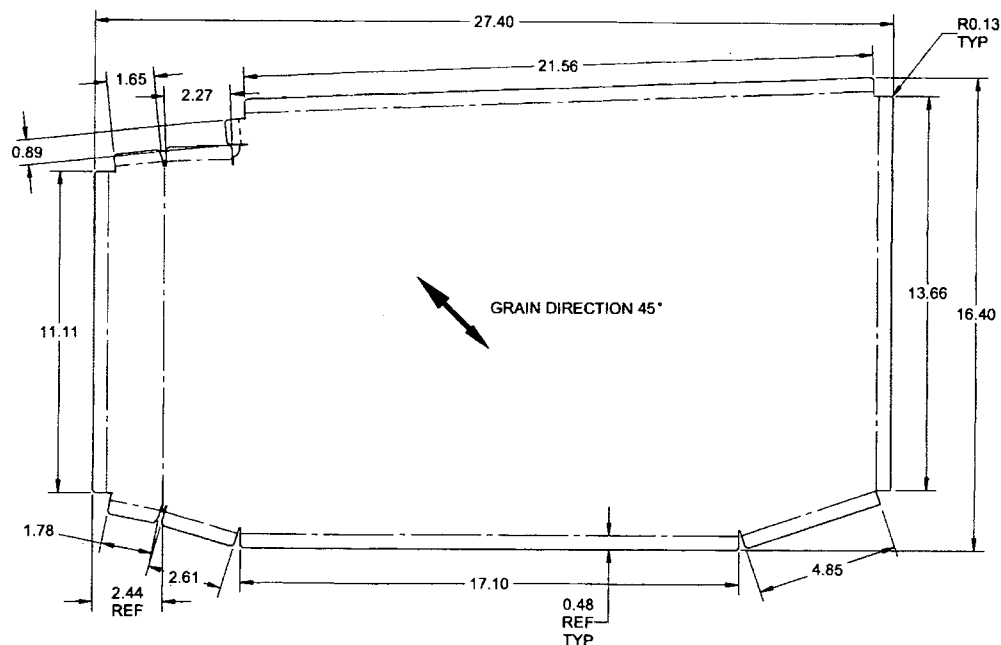
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72519

0.063
REF



D4055-7F FLAT PATTERN

RELEASED
2011-05-30
JW

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.56 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 11 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
DATE	11.05.12	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

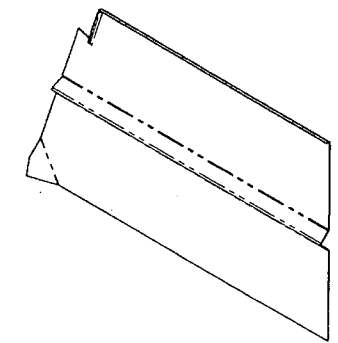
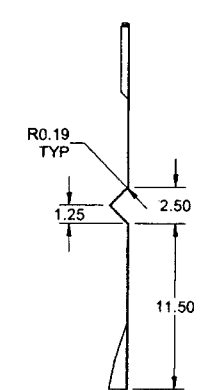
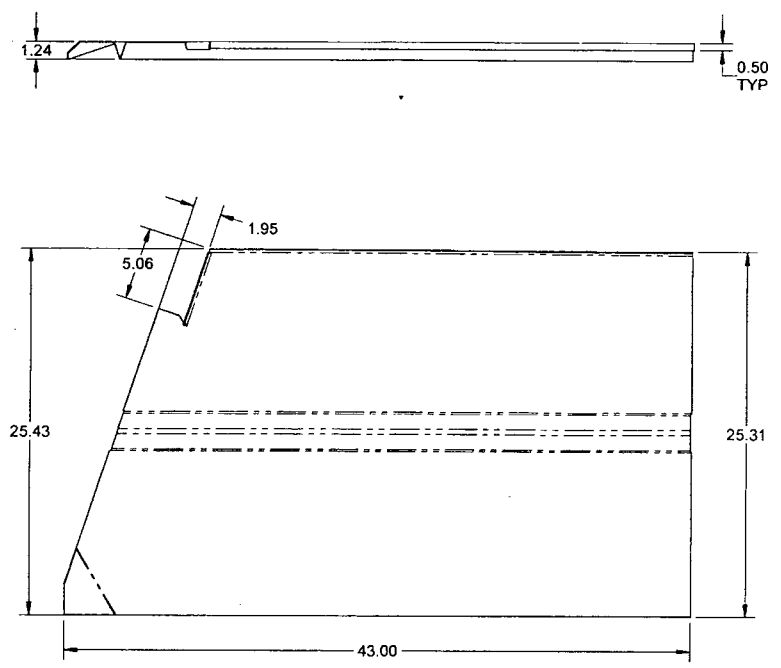
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72519



D4055-9 TANK BACK

RELEASED
2011-05-30
NW

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-9F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 6.41 lbs



DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4055	SHEET 12 OF 15
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

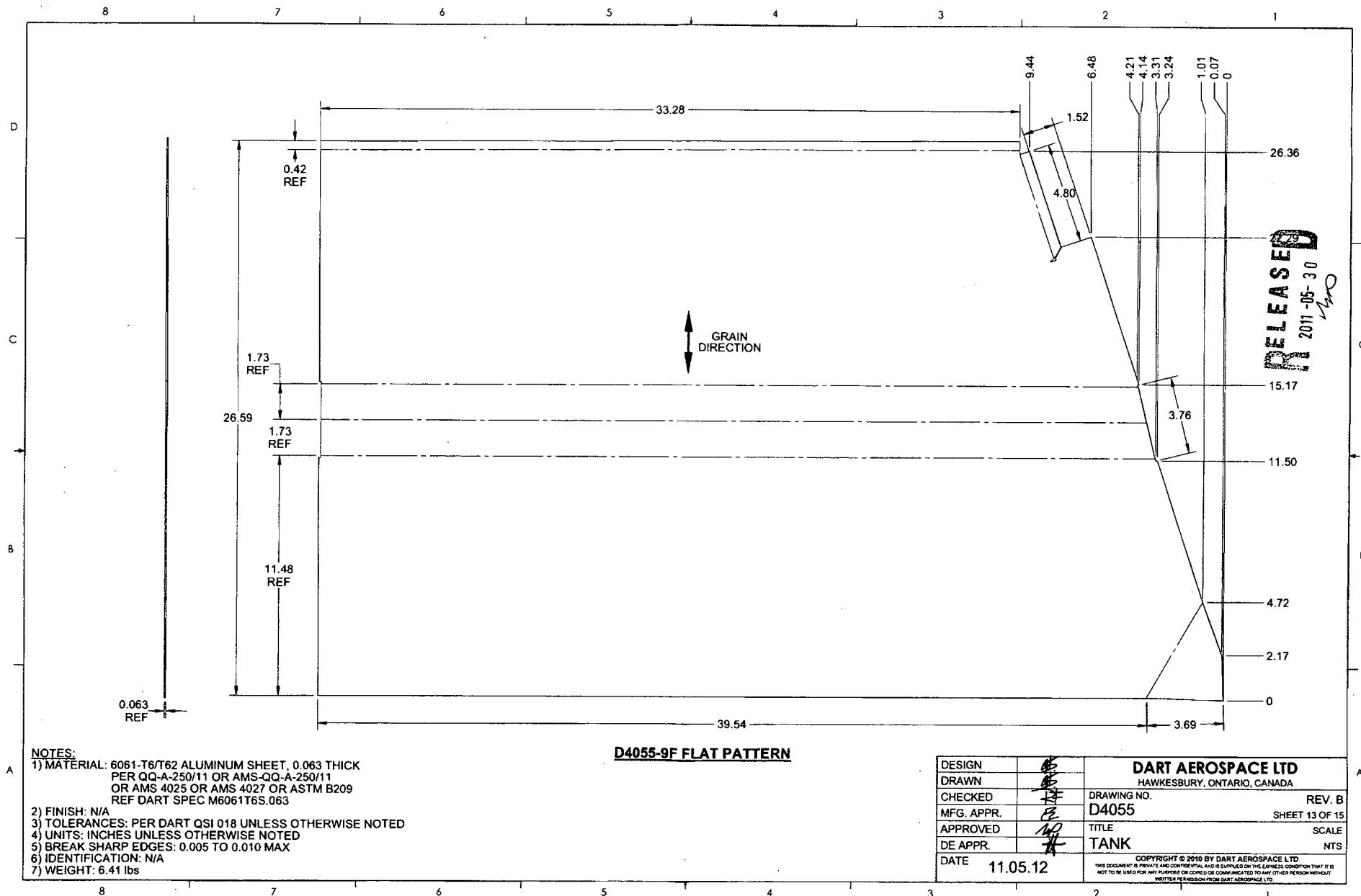
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72519



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

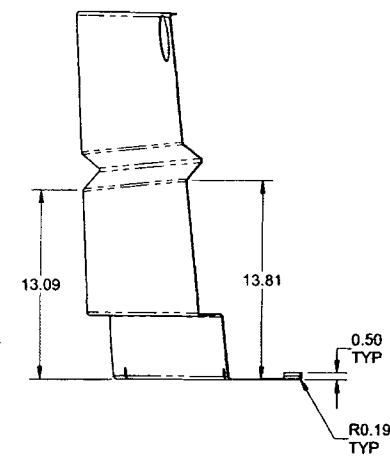
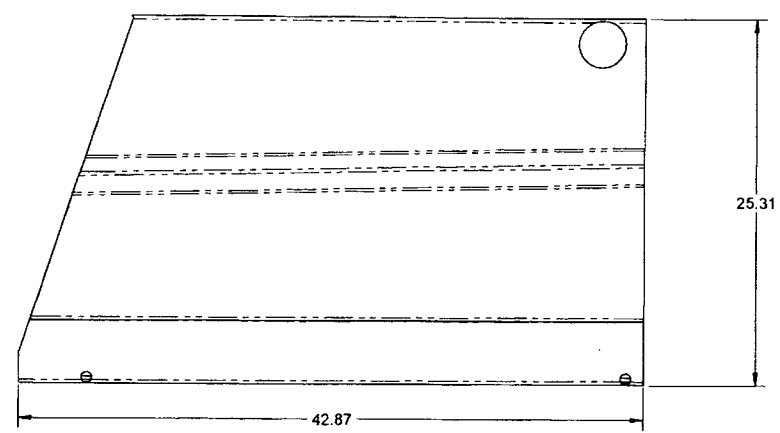
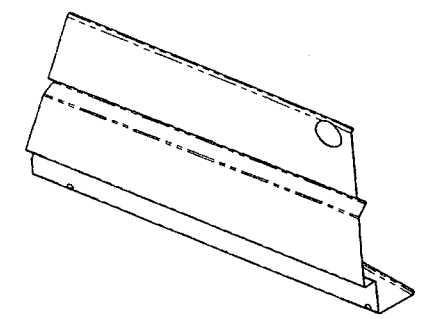
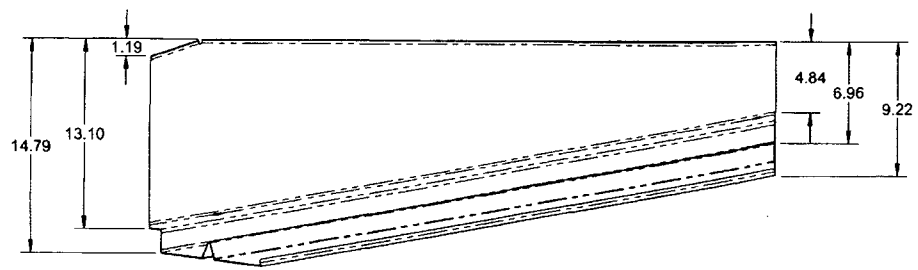
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72519



D4055-11 TANK FRONT AND BOTTOM

- NOTES:**
- 1) MATERIAL: MADE FROM D4055-11F
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 9.32 lbs



DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D4055	REV. B
MFG. APPR.		SHEET 14 OF 15	
APPROVED		TITLE	SCALE
DE APPR.		TANK	NTS
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

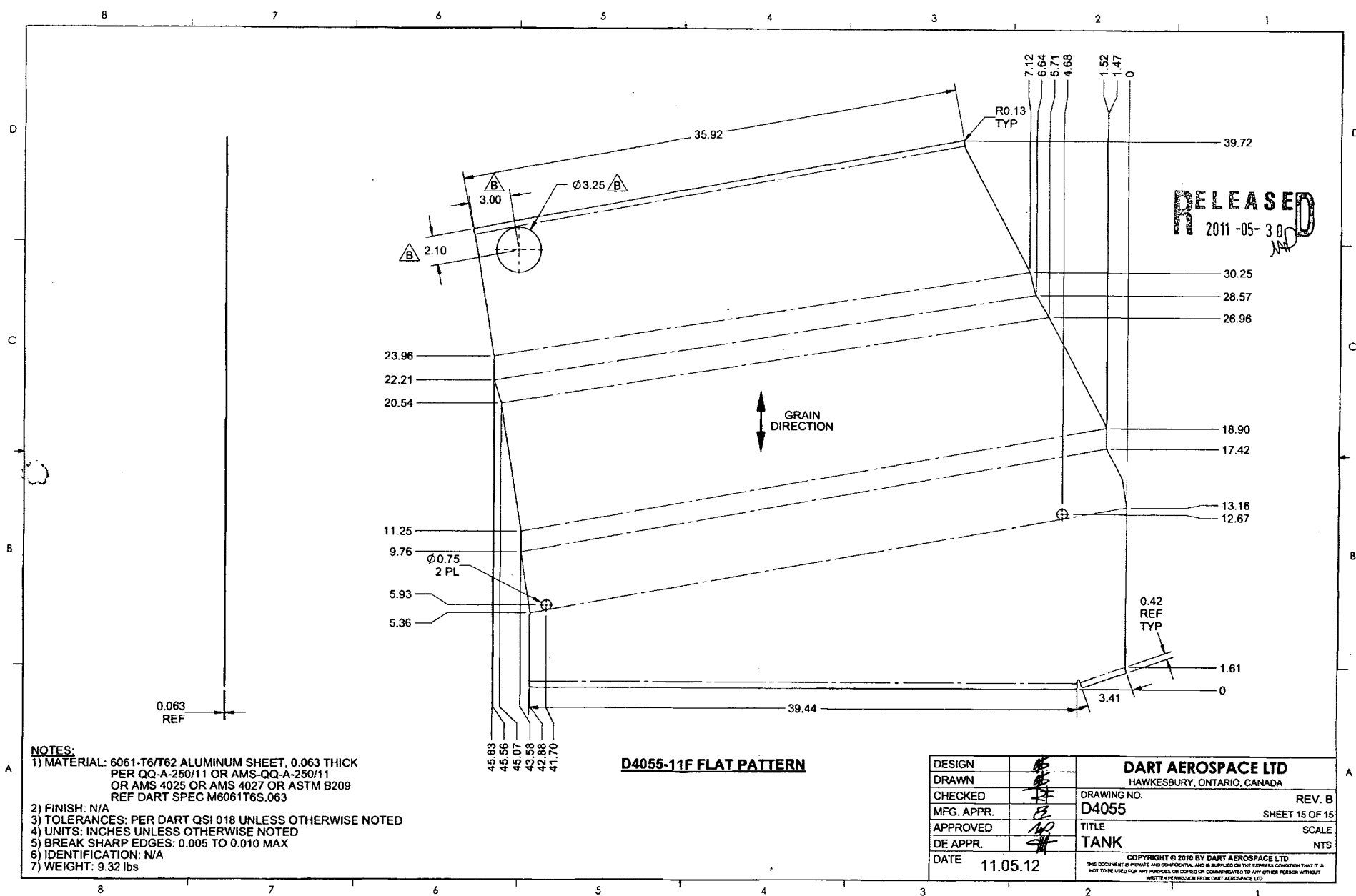
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

72519



W/O:		WORK ORDER CHANGES						
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries